



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-021
Job Sheet 193993



Part No: D350-636-021

Job Qty: 1 pcs

Part Name: AS350/355 - Skidtubes - Standard w/ Standard Wearplates - LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/24/19

Job Tracking No:

Due Date: 6/5/19

Created By: Shannon Hadley

Type: Stock

Description: SIOP

Note: D2750-051 REV.H / IIN-D350-636 REV.K IPP REV:A 18.11.23 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Skidtubes - 1	1 pcs	6/5/19		0.00	4.55	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		BE
							Skidtubes - 6		
							Skidtubes - 7		
110	Skidtubes - 2 - B4B	1 pcs	6/5/19		0.00	4.55	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		BE
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
120	QC 10	1 pcs	6/5/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		BE
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	6/5/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		

					QC 5 - 51	
					QC 5 - 58	DAS
					QC 5 - 68	MAY 01 2018
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
140	Handfinish - 1-1 Chemical-B4B	1 pcs	6/5/19	0.00 0.93	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R.19/05/02
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	QC 7	1 pcs	6/5/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	M64
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
160	Skidtubes - 3 - B4B	1 pcs	6/5/19	0.00 4.55	Skidtubes - 1 - B4B	DD
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	

170 QC 10	1 pcs	6/5/19	0.00 0.00	Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
180 QC 5	1 pcs	6/5/19	0.00 0.00	QC 10 - 58	MAY 15 2019 DAS 50 9-89
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	6/5/19	0.00 0.93	QC 5 - 24	MAY 15 2019 DAS 68 9-89
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
200 Spray Paint - 2 - B4B	1 pcs	6/5/19	0.00 0.91	QC 5 - 50	MAY 16 2019
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
				Spray Paint - 1 - B4B	
205 Outsource - 10 - Consignment	1 pcs	6/5/19		Spray Paint - 2 - B4B	19019-5-16
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
				Spray Paint - MJ1 - B4B	
				Spray Paint - MJ2 - B4B	
				Spray Paint - MJ3 - B4B	
				Spray Paint - MJ4 - B4B	
				ATE003-VC	
210 QC 14	1 pcs	6/5/19	0.00 0.00	5	19-5-21
				QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
230 Handfinish - 4-1-Assembly- B4B	1 pcs	6/5/19	0.00 0.93	QC 14 - 9	BEB 19-05-22
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	

				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
240 QC 5	1 pcs	6/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	DAS
				QC 5 - 49	19
				QC 5 - 51	9-09
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	6/5/19	0.00 0.00	Packaging 1 - 1 - B4B	MAY 27 2019
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	

260 QC 4	1 pcs	6/5/19	0.00 0.00	Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
				QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	MAY 2 8 2019
				QC 4 - 46	
270 Packaging 3-1 - Stock - B4B	1 pcs	6/5/19	0.00 0.00	QC 4 - 68	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	MAY 2 8 2019
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	6/5/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	MAY 2 8 2019
280 QC 21 - FG	1 pcs	6/5/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	MAY 2 8 2019

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D2750-5 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750 sheet 4 (D2750-5 details). Drill using drill Jig DT8150. 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6-Open up holes of Detail BF to 0.297" (total of 2 holes per side) and one 0.201" each side as per dwg 7-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 138989 8-Grind welds flush as per Dwg D2750
 120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - 1-Open up holes using hole saw of Detail BG and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 4-Chamfer holes of Detail BG, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5-Debur and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5163437 exp. date: 09/24/9 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 15) A/R Aluminum Rod batch: 138909 10-Grind welds flush as per Dwg D2750 11-Spot face ground handling holes section CS-CS (total of 4 places per side) as per dwg D2750 12-Debur holes, ensure tube is free of all scratches before sending to paint. + AIR 139011

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***

190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349

BATCH: 5163577 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5179097

210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-3, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 5174342 EXP DATE: 14-12-9 5-Coat all exposed fasteners with "LPS Procyon" batch: 14133640

240 - (QC5- Inspect part completeness to step on W/O)

250 - Pick Kit)

260 - (QC4- 100% Inspect kits for completeness) *****ensure antiseize is on AN8C21A bolts*****

270 - (Identify as per dwg & Stock Location: F6073) Package as per PPP D350-636-021 Location : FG108

275 - record fwd angle: 89.8 Photocopy blue file and type labels per PPP D350-636-021 CHG 001

280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	90-Skidtubes - 1	009875
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 2 - B4B	5166439
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 3 - B4B	5150291
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 3 - B4B	5153407
AN3C5A	Bolt	34 Ea (34 ea)	230-Handfinish - 4-1-Assembly-B4B	5162846
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5156446
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5049457
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5180978
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5160325
D3488-3	Blade Fitting, LH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5163736
D3537-1	Wearpad	3 pcs (3 ea)	230-Handfinish - 4-1-Assembly-B4B	5179042
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5175169
D3791-1	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5181118
D3793-1	Wearplate Fwd	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5180555
D3793-3	Wearplate Aft	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5176769
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5180226
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5149193
NAS1149C0332R	Washer	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5167203
NAS1149C0832R	Washer	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5148669
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5148669
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5083506
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5152647
D3793-5	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5152647
MS21043-3	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5161922
NAS1149C0363R	Washer	2 Ea (2 ea)	230-Handfinish - 4-1-Assembly-B4B	5099569
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5135000
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5149198
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5159549
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5167203
				5166718

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Skidtubes - 1	D2600-3-BENT-LH	1	7	0
	D2744	1	17	0
	D2739	1	9	0
110-Skidtubes - 2 - B4B	D2743	8	143	0
	ALS4-1032-225	38	1,681	0
160-Skidtubes - 3 - B4B	AN3C34A	1	12	0
	AN3C5A	34	1,547	0
	AN3C6A	4	317	0
	AN6C44A	4	132	0
	AN8C35A	1	62	0
	D2745	8	168	0
	D3488-3	1	3	0
	D3537-1	3	86	0
	D3631-1	8	197	0
	D3791-1	1	3	0
	D3793-1	1	5	0
	D3793-3	1	2	0
	D3793-5	1	15	0
	MS21043-3	1	1,018	0
	MS21043-6	4	154	0
	MS21083C8	1	210	0
	NAS1149C0332R	38	5,856	0
	NAS1149C0363R	2	437	0
	NAS1149C0832R	1	340	0
	NAS1515H3L	4	358	0
230-Handfinish - 4-1-Assembly-B4B	AN8C21A	2	85	0
	D2741	1	63	0
	MS21083C8	2	210	0
	NAS1149D0863J	2	465	0
250-Packaging 1-1 - Pick Kit - B4B				
Part Specifications				
Specifications could not be found.				

Plex 4/24/19 3:21 PM Dart.Hadley.Shannon

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X					D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X				D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X			D2750-044	350 SKIDTUBE ASSEMBLY, RH
				X		D2750-051	350 SKIDTUBE ASSEMBLY, LH
					X	D2750-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1						D2750-1	350 SKIDTUBE ASSEMBLY
	1					D2750-2	350 SKIDTUBE ASSEMBLY
		1				D2750-3	350 SKIDTUBE ASSEMBLY
			1			D2750-4	350 SKIDTUBE ASSEMBLY
				1		D2750-5	350 SKIDTUBE ASSEMBLY
					1	D2750-6	350 SKIDTUBE ASSEMBLY
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG
8	8					D3492-043	PLUG
		8	8			D3492-045	PLUG
3	3	3	3	3	3	D3537-1	WEARPAD
8	8	8	8	8	8	D3631-1	WASHER
1	1	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	1	1	D3793-5	WEARSHOE
38	38	38	38	38	38	ALS4-1032-225	INSERT
				1	1	AN3C34A	BOLT
34	34	34	34	34	34	AN3C5A	BOLT
4	4	4	4	4	4	AN3C6A	BOLT
4	4	4	4	4	4	AN8C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
				1	1	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
38	38	38	38	38	38	NAS1149C0332R	WASHER
				2	2	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.1 lbs
D2750-051/-052 = 25.7 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 19/64" SIZE HOLES (ϕ 0.297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

H	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D2750-041 (ZN C5-1 SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11/-12/-13/-14); D3793-5 REPLACES D3535-25 (ZN B8-1, C4-11/-12/-13/-14); NAS1149C0332R REPLACES AN860C10L (ZN A5-1, B1-11/-12/-13/-14, C7-11/-12/-13/-14); NAS1149C0832R REPLACES AN960C816L (ZN A5-1, C1-11/-12/-13/-14); REMOVED D3794-1/-3, AND D3536-25 GASKETS	ZF	18.03.05
G	CORRECTED TOLERANCE ON ϕ 0.500 THRU HOLE: IS +0.01/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS: ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 1 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED

2018 OCT 19
Z.N.18.830

APPROVED

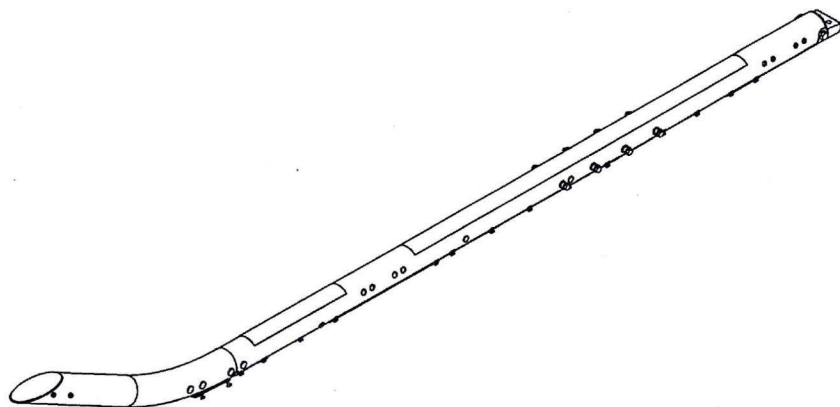
8 7 6 5 4 3 2 1

D

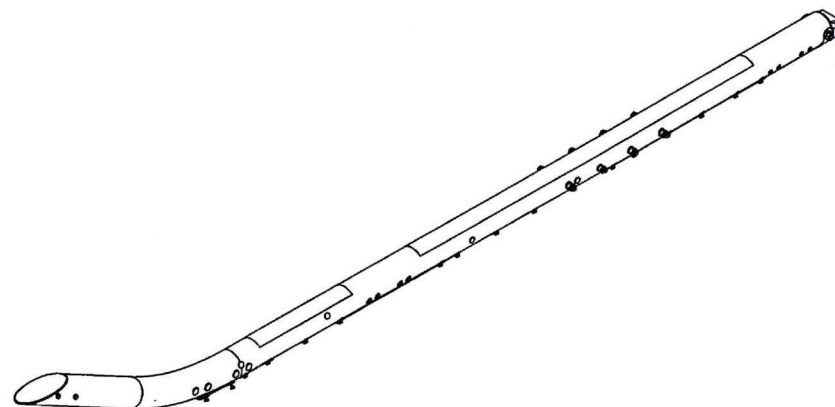
C

B

A



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED

2018 OCT 19
2018 10 19

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 2 OF 18
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

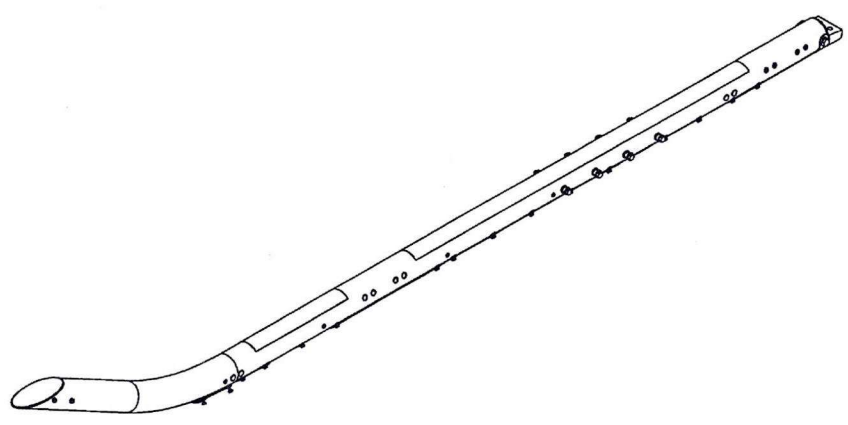
8 7 6 5 4 3 2 1

D

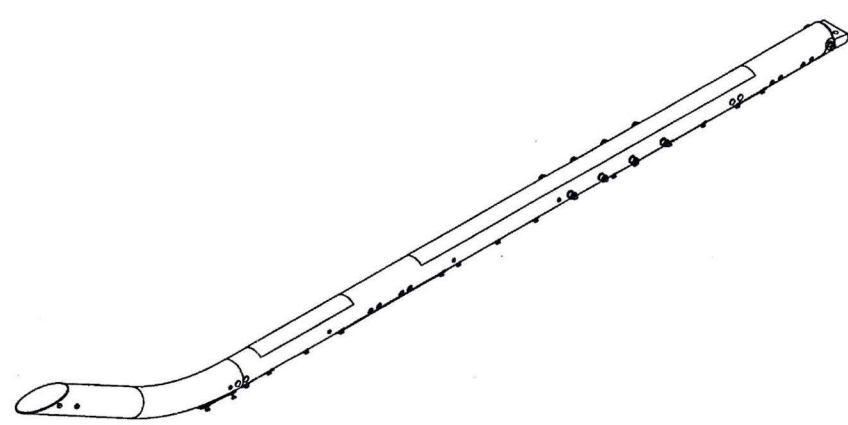
C

B

A



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

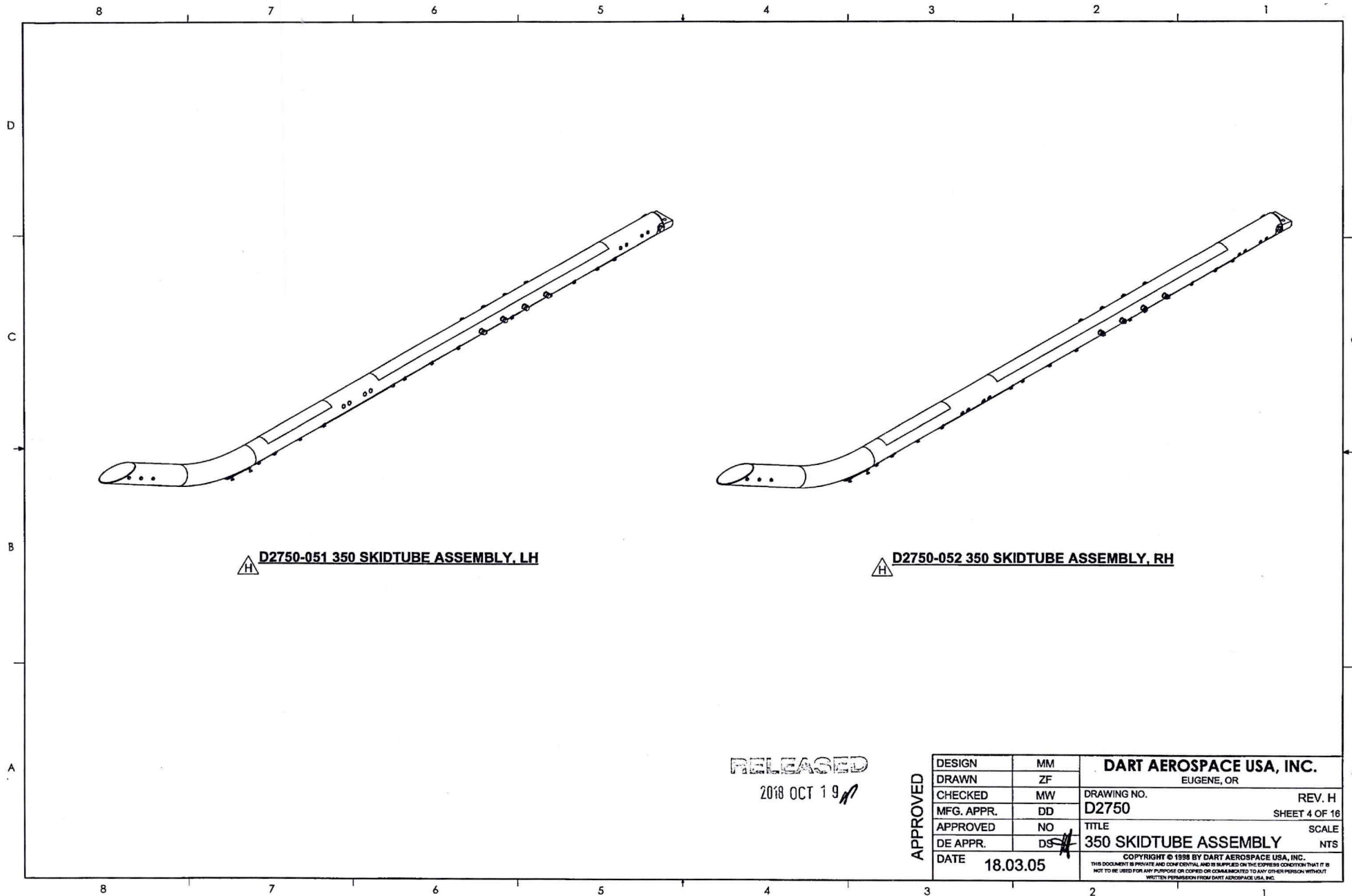
RELEASED

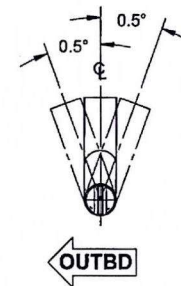
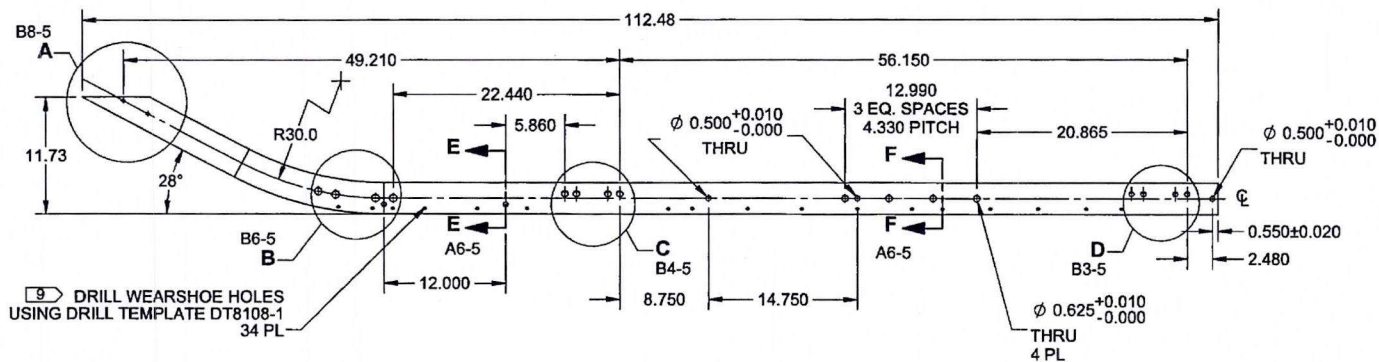
2018 OCT 19

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 3 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

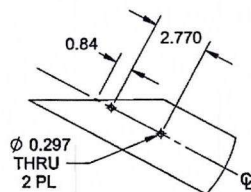
8 7 6 5 4 3 2 1



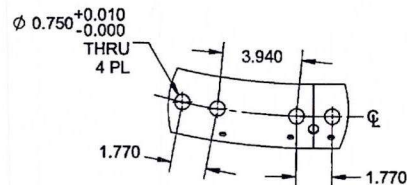


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)

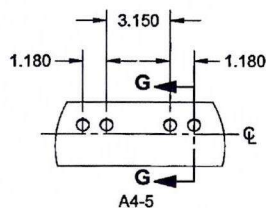
D2750-1 LH SKIDTUBE



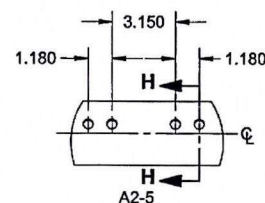
D7-5
DETAIL A
SCALE 2X



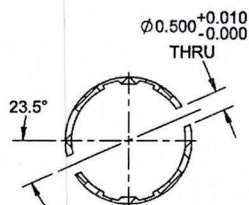
C7-5
DETAIL B
SCALE 2X



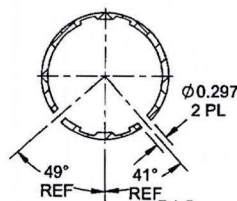
D5-5
DETAIL C
SCALE 2X



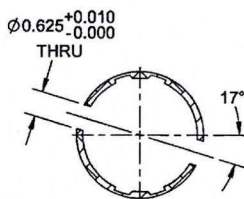
D3-5
DETAIL D
SCALE 2X



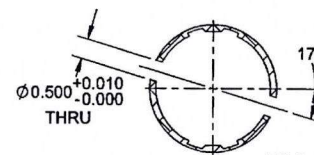
D5-5
SECTION E-E
SCALE 4X, 2 PL



D4-5
SECTION F-F
SCALE 4X, 17 PL



B4-5
SECTION G-G
SCALE 4X, 4 PL



B2-5
SECTION H-H
SCALE 4X, 4 PL

RELEASED
2010 OCT 19

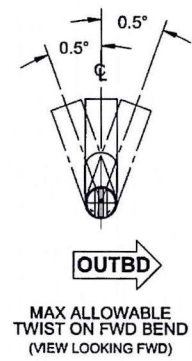
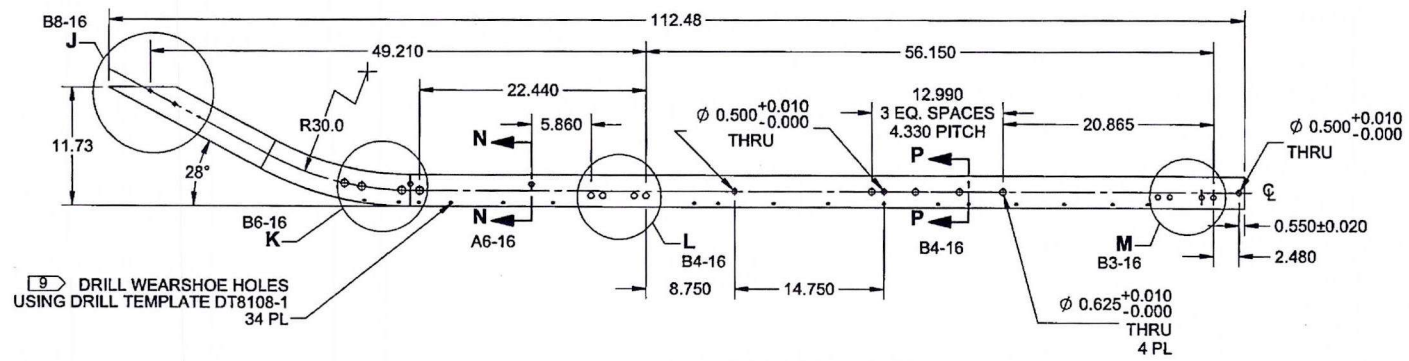
APPROVED

DESIGN	MM
DRAWN	ZF
CHECKED	MW
MFG. APPR.	DD
APPROVED	NO
DE APPR.	DS
DATE	18.03.05

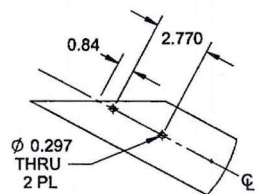
DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO. **D2750** REV. H
SHEET 5 OF 16
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

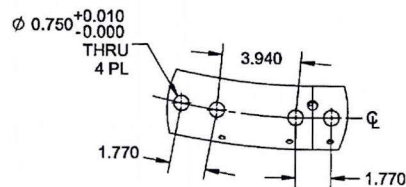
COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



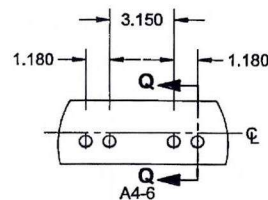
D2750-2 RH SKIDTUBE



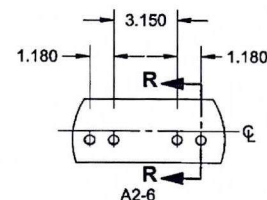
DETAIL J
SCALE 2X



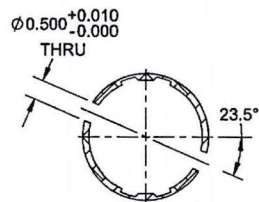
DETAIL K
SCALE 2X



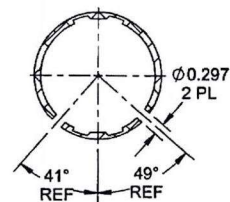
DETAIL L
SCALE 2X



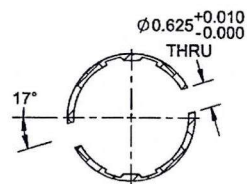
DETAIL M
SCALE 2X



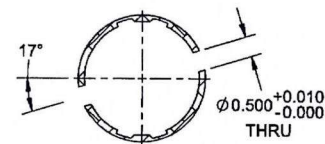
SECTION N-N
SCALE 4X, 2 PL



SECTION P-P
SCALE 4X, 17 PL



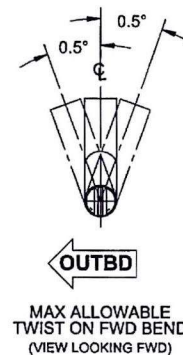
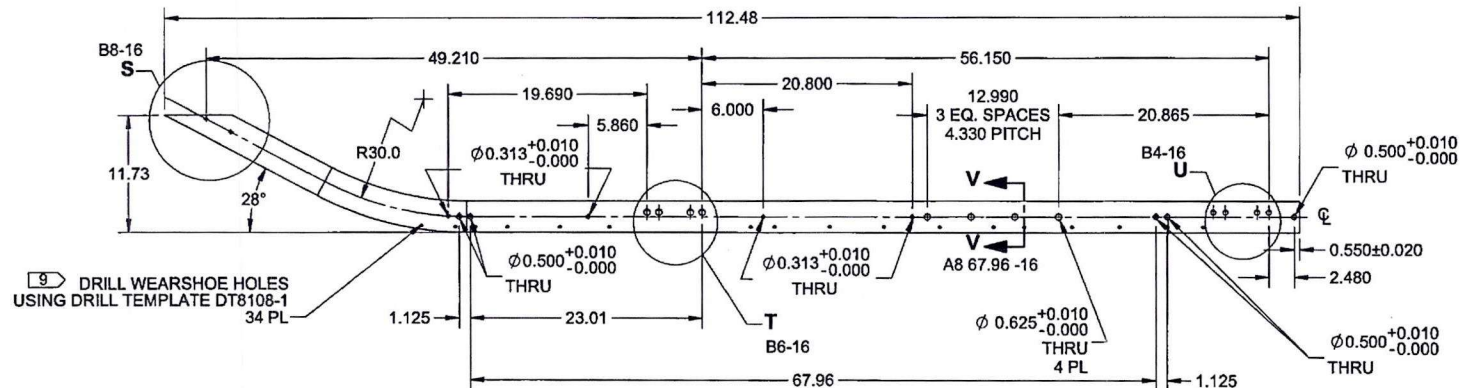
SECTION Q-Q
SCALE 4X, 4 PL



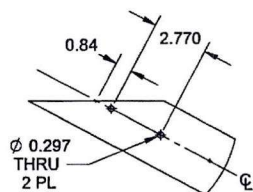
SECTION R-R
SCALE 4X, 4 PL

RELEASED
2018 OCT 19

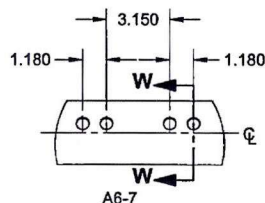
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 6 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



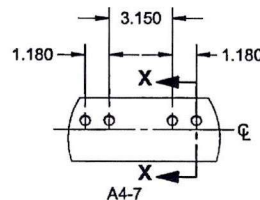
D2750-3 LH SKIDTUBE



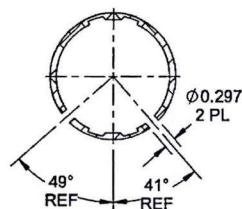
DETAIL S
SCALE 2X



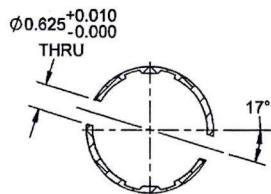
DETAIL T
SCALE 2X



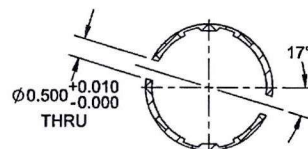
DETAIL U
SCALE 2X



SECTION V-V
SCALE 4X, 17 PL



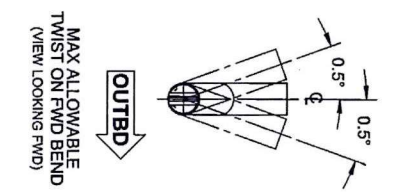
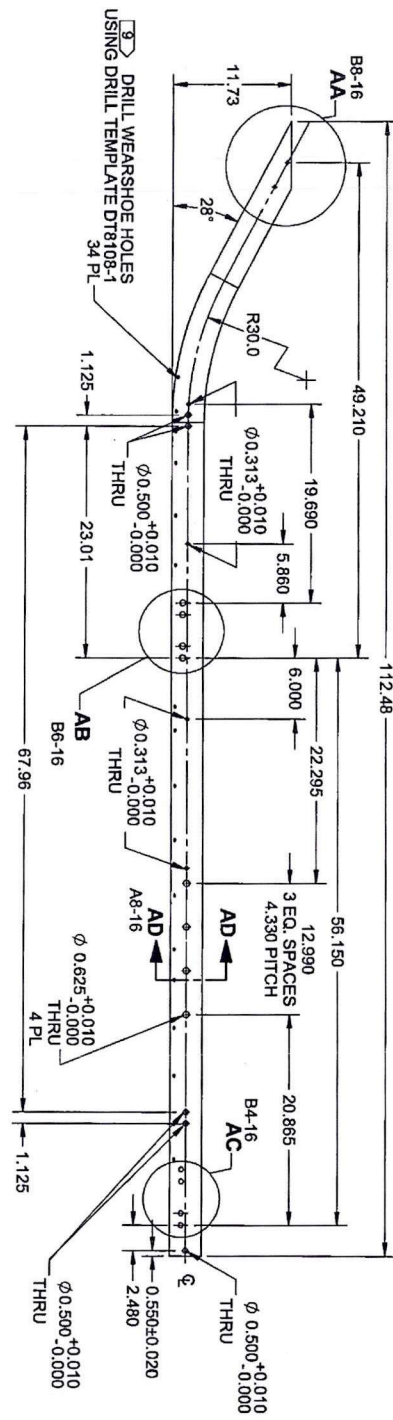
SECTION W-W
SCALE 4X, 4 PL



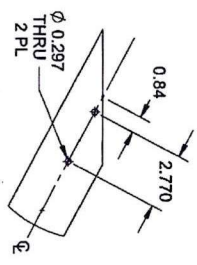
SECTION X-X
SCALE 4X, 4 PL

RELEASED
2009 OCT 19

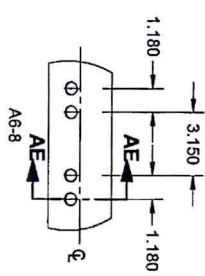
DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 7 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1995 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



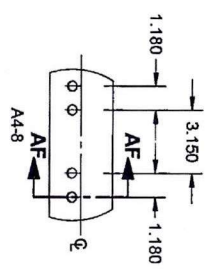
D2750-4 RH SKIDTUBE



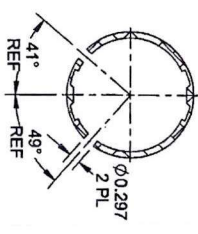
DETAIL AA
SCALE 2X
D7-8



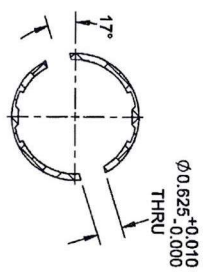
DETAIL AB
SCALE 2X
C5-8



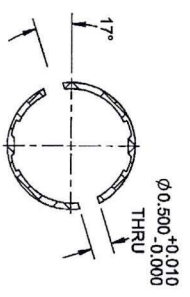
DETAIL AC
SCALE 2X
D3-8



SECTION AD-AD
SCALE 4X, 1/7 PL
D4-8



SECTION AE-AE
SCALE 4X, 4 PL
B6-8

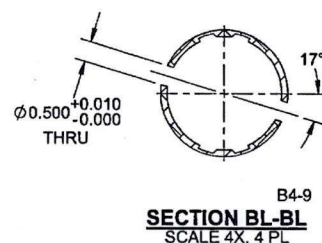
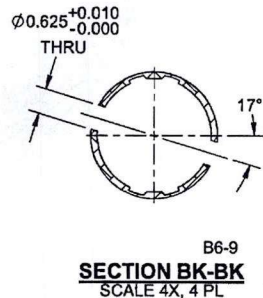
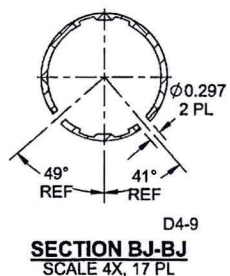
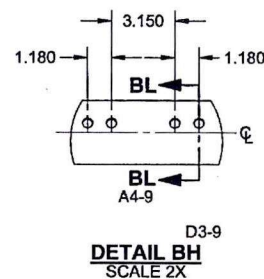
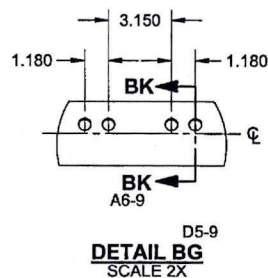
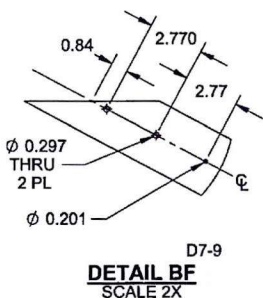
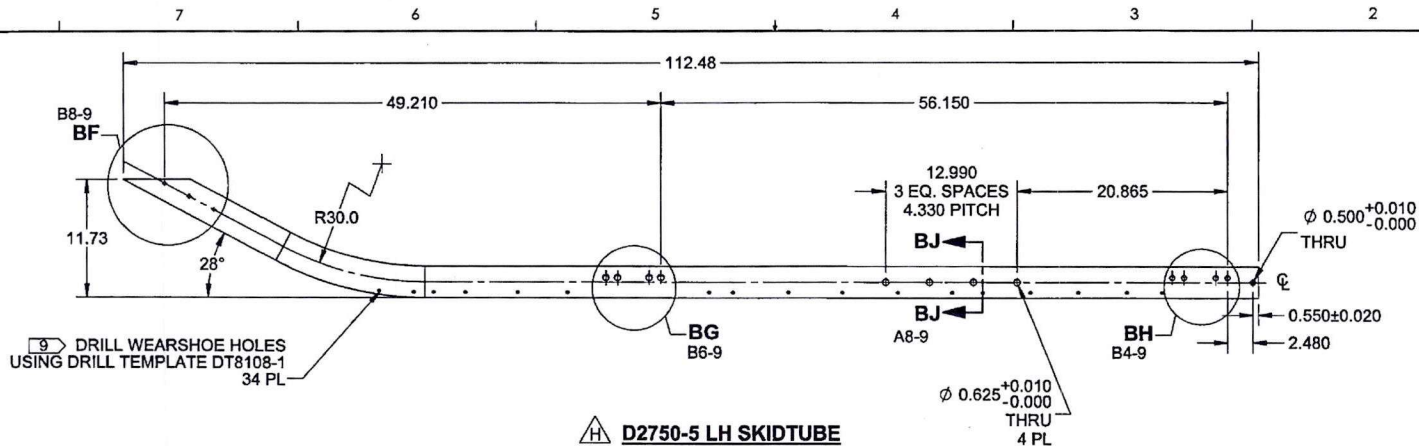


SECTION AF-AF
SCALE 4X, 4 PL
B4-8

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.
DRAWN	ZF	EUGENE, OR
CHECKED	MM	DRAWING NO.
MFG. APPR.	DD	D2750
APPROVED	NO	TITLE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY
DATE	18.03.05	SCALE
		NTS

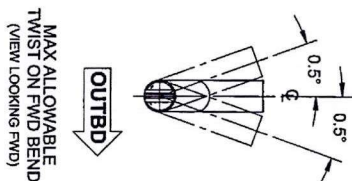
RELEASED
2010 OCT 19



RELEASED
2019 OCT 19

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 9 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



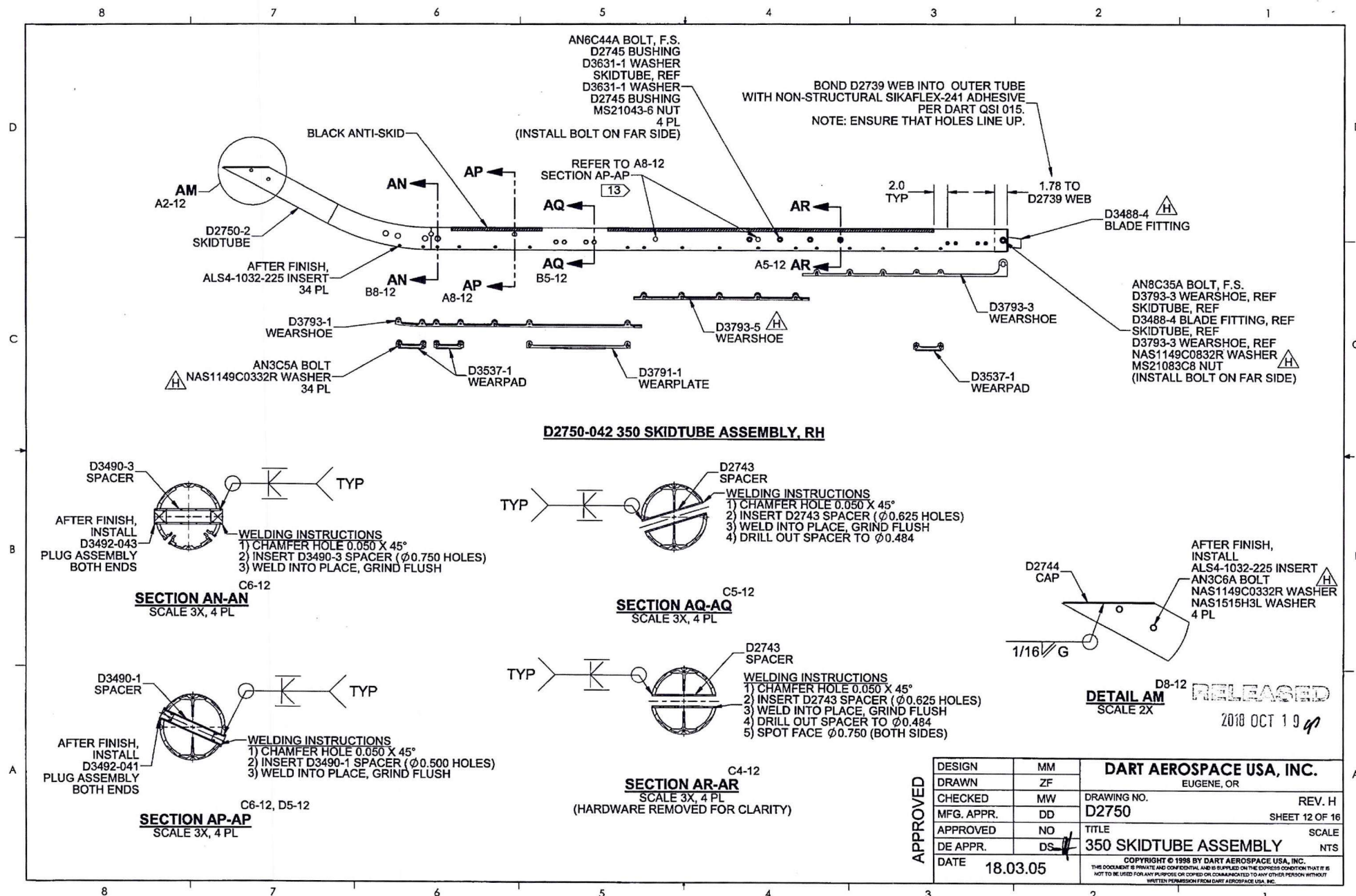
D2750-6 RH SKIDTUBE

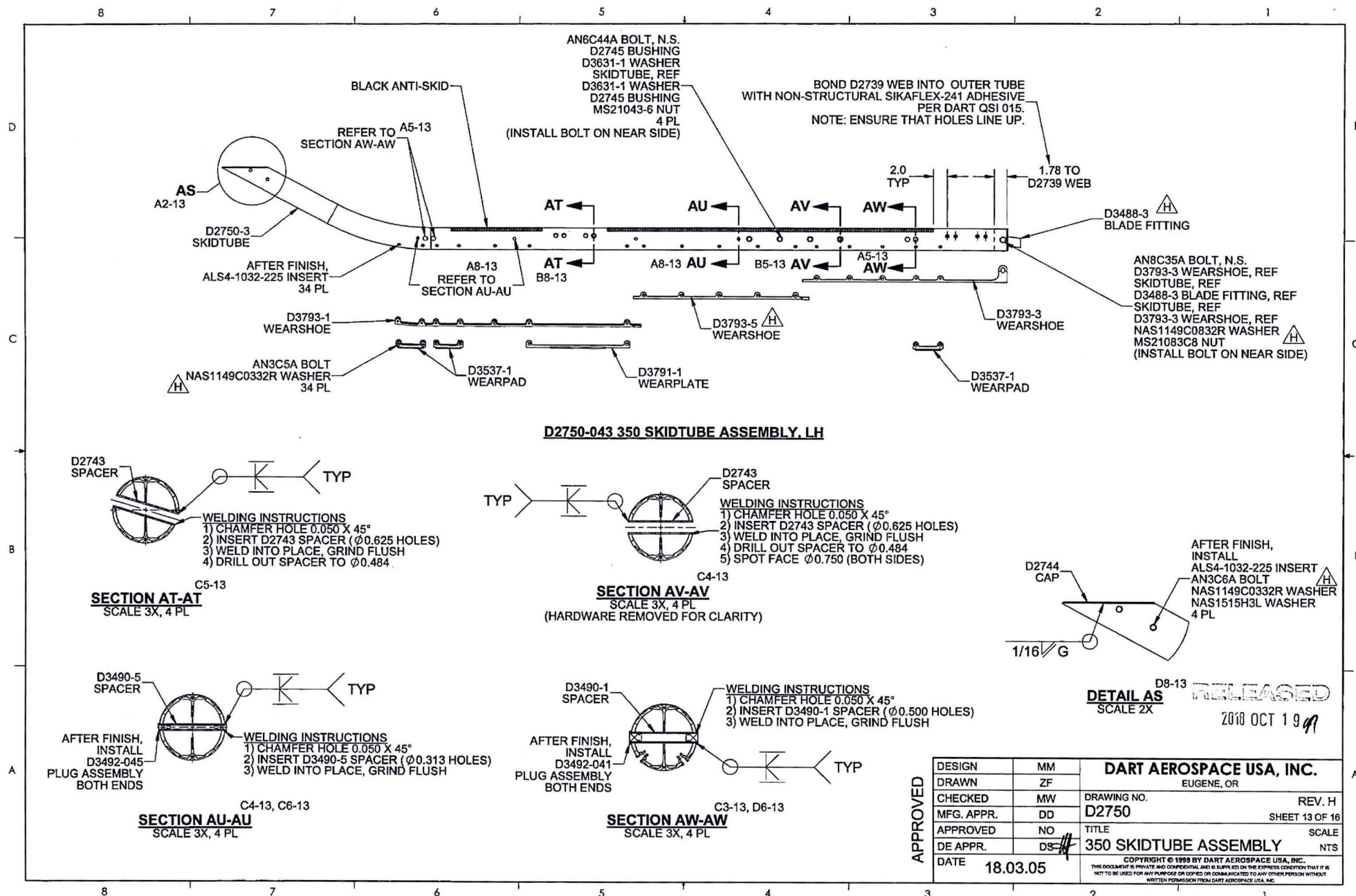


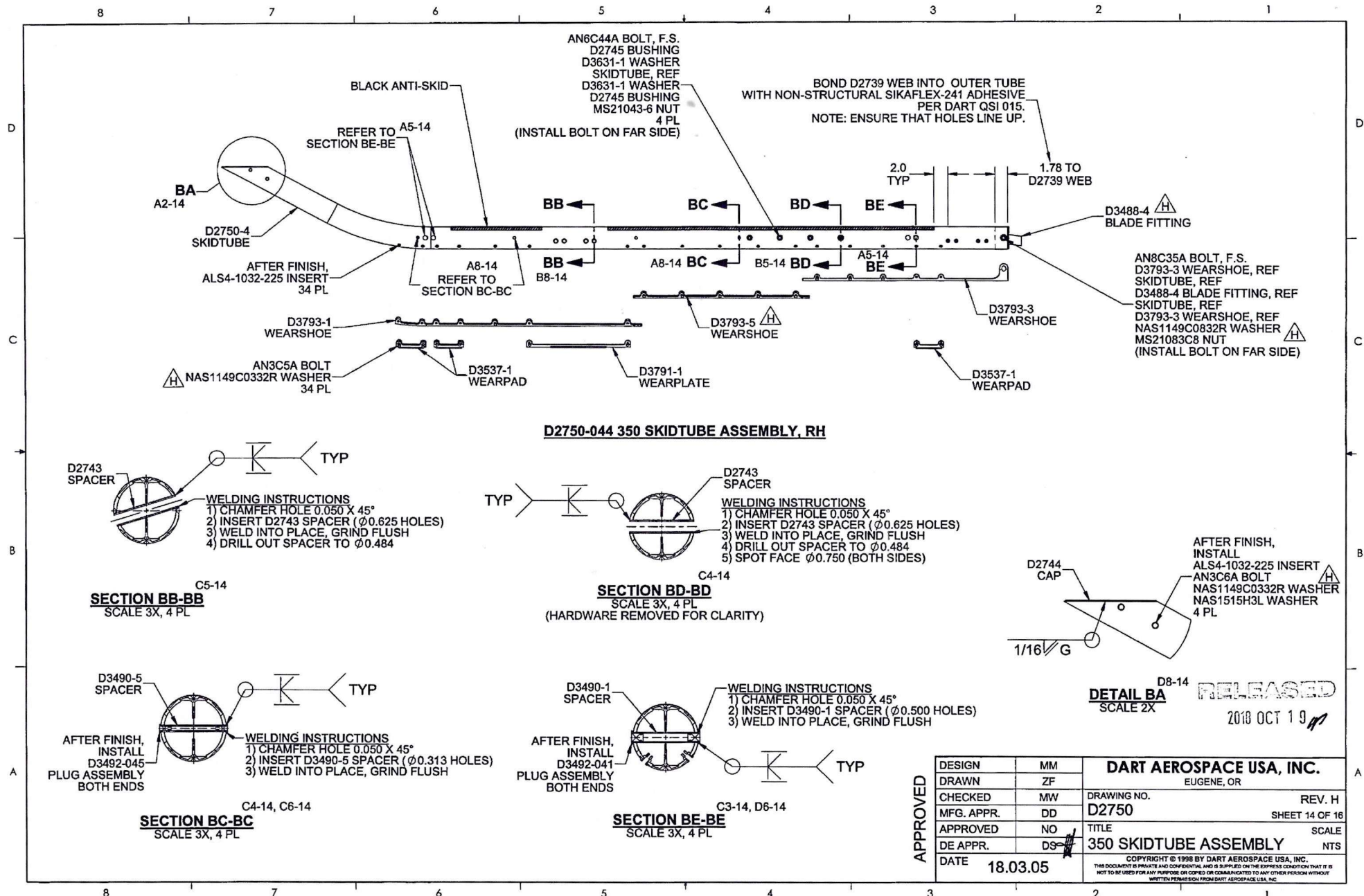
COPYRIGHT © 1996 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT
NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.

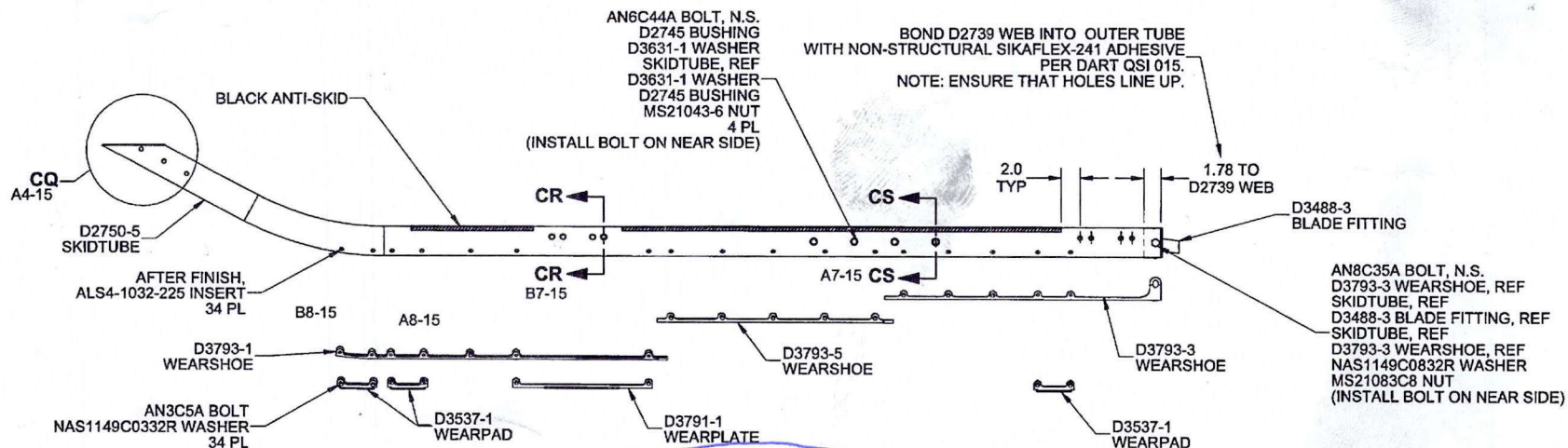
RELEASSED
2019 OCT 19
JG

1





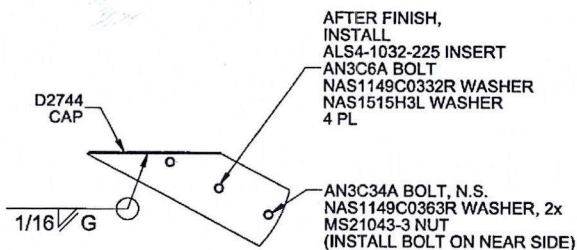




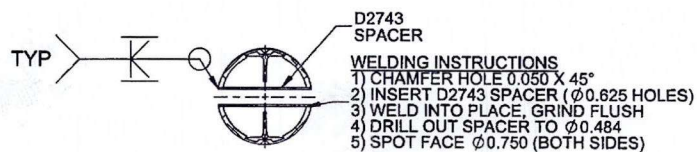
D2750-051 350 SKIDTUBE ASSEMBLY, LH



SECTION CR-CR
SCALE 3X, 4 PL



DETAIL CQ
SCALE 2X

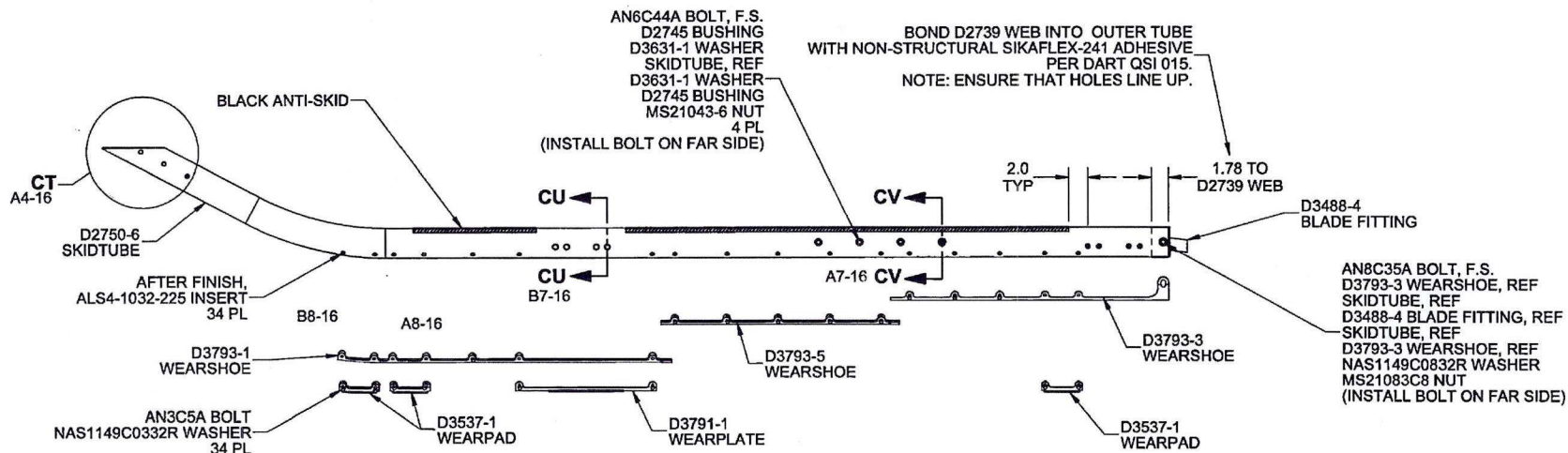


SECTION CS-CS
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

RELEASED

2018 OCT 19 92

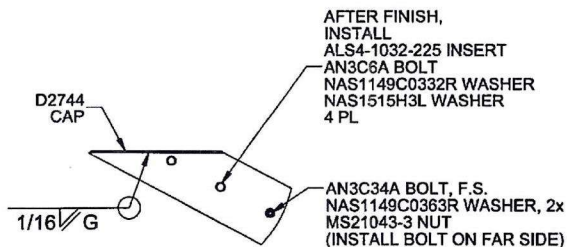
APPROVED	DESIGN	MM	DART AEROSPACE USA, INC.	
	DRAWN	ZF	EUGENE, OR	
	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 15 OF 15
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
	DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



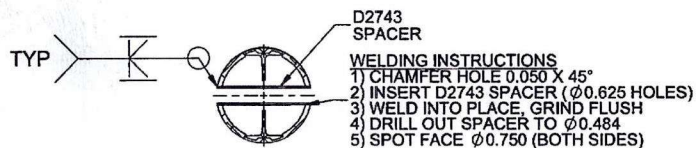
D2750-052 350 SKIDTUBE ASSEMBLY, RH



SECTION CU-CU
SCALE 3X, 4 PL



DETAIL CT
SCALE 2X

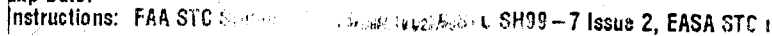


SECTION CV-CV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

RELEASED

2018 OCT 19

APPROVED	DESIGN	MM	DART AEROSPACE USA, INC.	
	DRAWN	ZF	EUGENE, OR	
	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 16 OF 16
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
	DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.				



1 813 632-5233
sales@dotter.com
artac@ace.com

5.0 PARTS LIST

D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 008 AND SUBSEQUENT
D350-636-021/-022 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
	X							D350-636-011	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
		X						D350-636-012	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
			X					D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
				X				D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
					X			D350-636-021	SKIDTUBE INSTALLATION, LH, STD
						X		D350-636-022	SKIDTUBE INSTALLATION, RH, STD
							X	D350-636-049	WEARSHOE KIT
1	1							D2750-041	SKIDTUBE ASSEMBLY, LH
1		1						D2750-042	SKIDTUBE ASSEMBLY, RH
1			1					D2750-043	SKIDTUBE ASSEMBLY, LH
1				1				D2750-044	SKIDTUBE ASSEMBLY, RH
1					1			D2750-051	SKIDTUBE ASSEMBLY, LH
1						1		D2750-052	SKIDTUBE ASSEMBLY, RH
*1	1							D2750-1	SKIDTUBE WELDMENT, LH
*1		1						D2750-2	SKIDTUBE WELDMENT, RH
*1			1					D2750-3	SKIDTUBE WELDMENT, LH
*1				1				D2750-4	SKIDTUBE WELDMENT, RH
1					1			D2750-5	SKIDTUBE WELDMENT, LH
1						1		D2750-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149C0832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
8	1		1		1			D3488-3	BLADE FITTING, LH
8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149DO863J	WASHER
11C							8	D3672-1	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149C0332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER
*22	3	3	3	3	3	3	3	D3537-1	WEARPAD

• COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR
COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: K

Date: 18.04.04